

BRAZING PROCEDURE SPECIFICATION

BPS: 6000-102-F102 **REV. NO.:** 0 **DATE:** 8/15/2006 ****APPLICABILITY****

BRAZING PROCESS: TB and TB ASME: X AWS: X OTHER:

SUPPORTING POR: 6000-8-F102

JOINT: This BPS shall be used in conjunction with the General Welding Standards (GWS) and Welding Fabrication Procedure (WFP) sections and criteria for joint details, repairs, NDE, inspection etc.

Joint Type: Lap/Socket Class: Full flow

See GWS 1-06 and WFP's for joint details Preparation: Square tube ends and abrasive cloth/SS wire brus

Clearance: 0.125 Brazed Joint Overlap Min.: 4T* Max.: 0.75

FILLER METALS:

AWS Specification: 5.8 and 5.8 AWS Class: BAg-7 and BAg-7

F No: 102 **and** 102 **A No:** N/A **Size:** 3/32 1/8

Filler Material Type: Solid Insert: N/A Insert Type: N/A

Filler Material Notes: 56Ag/22Cu/17Zi

BASE MATERIALS:

P/S No. 102 Gr No. 1 to: P/S No. 102 Gr No. 1

Spec. A-312 - SS-Smls & welded pipe Grade: All to: Spec. A-312 - SS-Smls & welded pipe Grade: All

Qualified Thickness Range: AWS: 0.032 thru 0.125 ASME: 0.032 thru 0.125

FLOW POSITIONS:

Qualified Positions: AWS: All ASME: FF, HF, VU Flow Direction: V-Up/Horz.

BRAZING FLUX, FUEL GAS, or ATMOSPHERE:

Flux: Type or Trade Name: FB3C Black or equal

Fuel Gas: Acetylene Flame: Neutral Braze temp. °F 1150 to 1600

Backing Gas: N/A **Composition:** 0 % **Backing Gas Flow cfh:** 0 **to** 0

POST BRAZE HEAT TREATMENT:

Heat Treatment Temperature: N/A °F Max. Time at Temperature: N/A

BRAZING TECHNIQUE: For fabrication specific requirements such as fitup, cleaning, grinding, PWHT and

inspection criteria refer to Volume 2, Welding Fabrication Procedures

Cleaning Method: Abrasive cloth/SS wire brush/file Tip Size: #6

APPROVAL: Signatures on file at FME DES **DATE:** 8/16/2006

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Comments: T =the thickness of the thinner member to be brazed.

Use of LANL Welding Procedures and Welder Qualifications for non-LANL work shall be at the sole risk and responsibility of the Subcontractor, and the Subcontractor shall indemnify and save LANL and the Government harmless from any and all claims, demands, actions or causes of action, and for any expense or loss by reason of Subcontractor's and their employees posession and use of LANL procedures and qualifications.

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